

**Work Order ID. 85178**

Monday, June 04, 2012 10:48:19 AM

**\*85178\****ASAP*

Page 1

Item ID: D3440-9

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Date: 6/4/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-06-04* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3440

Rev A

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.250" x 1.250" x 1.825" long

*PO**12/06/08**4**Ø**FK. 12/06/09.*

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA535 and Dwg D3440Dwg Rev: A Identify as  
D3440-9Folio Rev: A Debur*FK 12/06/09**4**PTO →*

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*FK 12/06/09.**4*

W/O: 85178

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3440-9 PAR #: \_\_\_\_\_ Fault Category: Machin NCR: Yes No DQA: AK Date: 12/06/16  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: CK Date: 12/6/18

NCR: 12-1500		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/09	110	Tap Fatigue, <del>used</del> the tool broke in the part P.C. tooling /	S AS7047 12/06/11	SCRAP & Destroy and Replm B <u>119318</u>	FL 12/06/11	SL ET 12-06-11	S AS7047 12/06/11	S 12/06/14

NOTE: Date &amp; initial all entries

**Work Order ID 85178**

Monday, June 04, 2012 10:48:19 AM

**\*85178\***

Page 2

Item ID: D3440-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Date: 6/4/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

JL/AR 12-06-11 (x4)

140

Identify as per dwg &amp; Stock Location: PAT

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

R

12/6/11 (4)

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12/6/12 JF  
MF  
12-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 04, 2012 10:48:18 AM

Page 1

Work Order ID: 85178

Parent Item: D3440-9

Parent Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Date: 6/4/2012

Required Date: 6/15/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.06.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased	No			100	f	18.2900	0.1625	0.6842105			

PO 12/06/08

Location

Loc Qty

Loc Code

MAT004

18.29



119318

18.29

119318

0.7

.23 F.K. 12/06/09.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

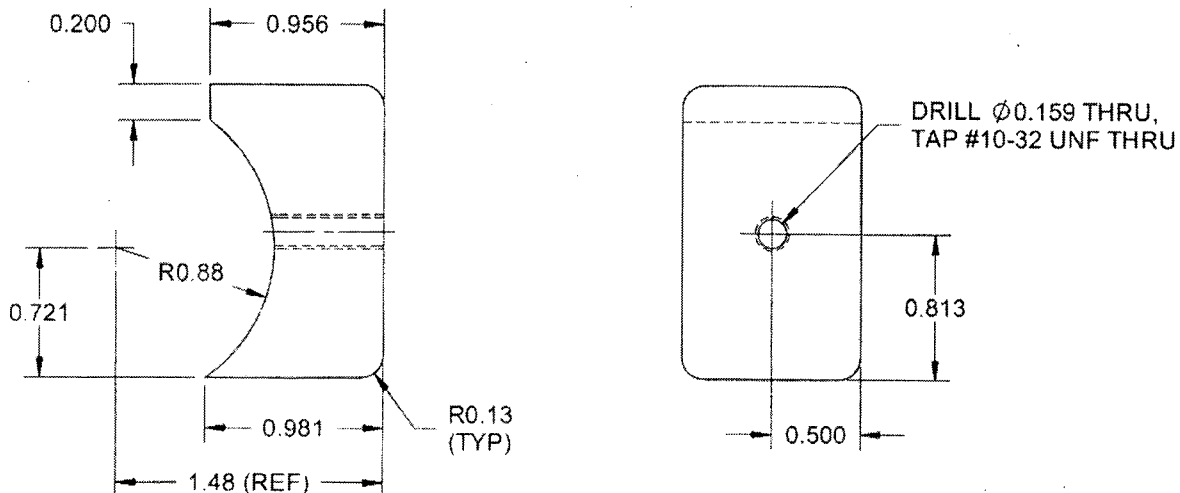
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



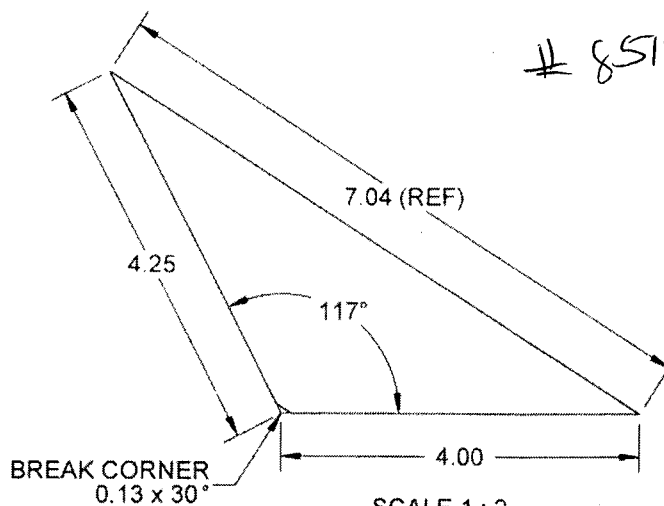
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b> REV. A SHEET 5 OF 7
DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

*RELEASED*  
*05/08/13*



SCALE 1:2

**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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